

20-8510



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

PL SEP 25 2020

Job Sheet 212751



D2958

Part No: D2958

Job Qty: 6 pcs

Part Name: Window



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/2/20

Job Tracking No:

Due Date: 9/30/20

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV E IPP E: 01.09.25 Done by outside contract SM IPP F: 07.06.26 Thermoform in house DL IPP G:
07.09.28 Rev E dwg EC verified by: DD IPP H: 08.11.24 Step 8 revised per w/o 41134 KJ Verified by: EC IPP
Rev I 14/01/20 Change "Folio" to Work Instruction DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	Purchasing	6 pcs	9/30/20		0.00	0.00	Purchasing - 1 Purchasing - 2 Purchasing - 3	SEP 25 2020
140	Packaging 2-1 - Receive - B4B	6 pcs	9/30/20		0.00	0.00	Packaging 2 - 1 - B4B Packaging 2 - 2 - B4B Packaging 2 - 3 - B4B Packaging 2 - 5 - B4B Packaging 2 - 4 - B4B Packaging 2 - 6 - B4B Packaging 2 - 7 - B4B Packaging 2 - 8 - B4B Packaging 2 - 9 - B4B Packaging 2 - 10 - B4B Packaging 2 - 11 - B4B Packaging 2 - 12 - B4B Packaging 2 - 13 - B4B Packaging 2 - 14 - B4B Packaging 2 - 15 - B4B Packaging 2 - 16 - B4B Packaging 2 - 17 - B4B Packaging 2 - 18 - B4B Packaging 2 - 19 - B4B Packaging 2 - 20 - B4B Packaging 2 - 21 - B4B Packaging 2 - 22 - B4B Packaging 2 - 23 - B4B Packaging 2 - 24 - B4B Packaging 2 - 25 - B4B Packaging 2 - 26 - B4B Packaging 2 - 27 - B4B	SEP 25 2020



Container No: S303080



Part: D2958

Job No: 212751

Serial No/Batch: S303080

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 9/25/20

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 (613) 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
150	QC 6	6 pcs	9/30/20	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
					QC 6 - 82	
170	Packaging 3-1 - Stock - B4B	6 pcs	9/30/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
180	QC 21 - SA	6 pcs	9/30/20	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 9	
					QC 21 - SA - 77	
					QC 21 - SA - 28	

Part Op 110 - (Purchasing)ISSUE P/O:

SUPPLIER:PLASTECH MANUFACTURE D2958 AS PER

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Descriptions: DWG C OF C IS REQUIRED

- 140 - (Receive & Inspect for Damage & Mat'l Certs)
- 150 - (QC6- All purchased or subcontracted products)
- 170 - (Identify as per dwg & Stock Location: _____)
- 180 - (QC21- Final Inspection - Work Order Release)

PO Details

Canus Plastics Inc (ptf001-vc)



PO No: POHB047008

Line No: 1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2958P	Window	6 Ea (1 ea)	110-Purchasing	8303077
MACRLICS.125	1/8" Polycast li Sheet	63.9600 sf (10.66 ea)	110-Purchasing	5151992

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2958P	6	0	0
	MACRLICS.125	64	1,111	0

Part Specifications

Specifications could not be found.

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB047191**



Previous POHB047008 not working at

Supplier: PTF001-VC
Canus Plastics Inc
3030 Conroy Unit 107
Ottawa Ontario

K1G 6C2 Canada
Phone: 613-831-4640
Fax: 613-831-4624

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB047191

PO Date: 9/25/20

Due Date: 9/30/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Lussier, Patrick
Phone: 613-632-5200 Ext: 276
plussier@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments: Replacement for POHB047008 not working in
Plex

*receiving
create new PO
SEP 25 2020*

Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	212751	D2958P	D2958 Rev.E			Window : Various STC's As Per Dwg D2958 Rev. E	Firmed	-	9/30/20	3 Ea	0 Ea	3 Ea	\$275.00/Ea	\$825.00
							X3	DAS 32 9-89		SEP 25 2020				
2	213444	D2958P	D2958 Rev.E			Window : Various STC's As Per Dwg D2958 Rev. E	Firmed	-	9/30/20	3 Ea	0 Ea	3 Ea	\$275.00/Ea	\$825.00
													Grand Total:	\$1,650.00

Order Notes

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit
www.dartaerospace.com for further explanation.

Please ensure to send the related invoice to hby_ap@dartaero.com.

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Sheet 1 of 1

[illegible]

SAE AS9102 First Article Inspection Form

Form 2: Product Accountability – Raw Material, Specifications and Special Process(es), Functional Testing

Sheet 1 of 1

1. Part Number D2958	2 Part Name WINDOW		2. Serial Number 2020-001		4. FAI Report Number FAIR-D2958 Rev E
5. Material or Process Name	6. Specification Number	7. Code	8. Special Process Supplier Code	9. Customer Approval Verification (Yes/No/NA)	10. Certificate of Conformance number
PLEXIGLAS G CLEAR CAST ACRYLIC SHEET	LP-391 TYPE 1 GRADE C, 0.125 THICK REF. DART SPEC. M-ACRYLIC-S.125		N/A	N/A	N/A Supplied by Customer_ DART
11. Functional Test Procedure Number	12. Acceptance report number, if applicable				
13. Comments					
14. Prepared By Mark Perry CANUS PLASTICS			15. Date 09-25-2020		

SAE AS9102 First Article Inspection Form

Form 3: Characteristic Accountability, Verification and Compatibility Evaluation

Sheet 1 of 2

1. Part Number D2958				2. Part Name Window			3. Serial Number 2020-001	4. FAI Report FAIR-D2958 Rev E
Characteristic Accountability				Inspection / Test Results				
5. Char No.	6. Reference Location	7. Characteristic Designator	8. Requirement	9. Results	10. Designed Tooling	11. Non-Conformance Number	14. Remarks.	
1	6B, Eng. Note 1		MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M- ACRYLIC-S.125	CHECKED Plexiglas G Acrylic sheet .125			Material supplied by customer _ Dart Material M-ACRYLIC.S.125 Batch# S151992. ✓	
2	6A, Eng. Note 2		FINISH: NONE	NOTED				
3	6A, Eng. Note 3		TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED	NOTED				
4	6A, Eng. Note 4		UNITS: INCHES UNLESS OTHERWISE NOTED	NOTED				
5	6A, Eng. Note 5		REMOVE SHARP EDGES	SCRAPED BOTH EDGES TO REMOVE.				
6	6A, Eng. Note 6		IDENTIFICATION: ENGRAVE P/N "D2958" AND B/N ON LOWER EDGE USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"	NOTED			- Tag or label only by CANUS PLASTICS - Final Identification to be completed by Dart per Eng. Note 6.	
7	6A, Eng. Note 7		WEIGHT: 1.58 +/- 0.35 Lbs.	2 LB			PLASTECH WEIGH SCALE IS +/- 1 LB ACCURACY.	
8	6A, Eng. Note 8		MOLD PER DART TOOL DT8567	NOTED	MOULD DT8567			

Form 3: Characteristic Accountability, Verification and Compatibility Evaluation

Sheet 2 of 2

4. Part Number D2958				5. Part Name WINDOW			3. Serial Number 2020-001	4. FAI Report FAIR-D2958 Rev E
Characteristic Accountability				Inspection / Test Results				
5. Char No.	6. Reference Location	7. Characteristic Designator	8. Requirement	9. Results	10. Designed Tooling	11. Non-Conformance Number	14. Remarks.	
9	4C		R1.85 (TYP 3 PL., REF)	R1.85 ✓				
10	4C		8.87 (REF)	8.85 ✓				
11	3C		16.00 (REF)	16.0 ✓				
12	3C		0.88 (REF)	0.85 ✓			CONTROLLED BY MOULD. PART CONFORMS TO MALE MOULD WITHOUT ANY GAPS POST COOLING.	
13	6D		22.70 (REF)	22.65 ✗				
14	7D		9.84 (REF)	9.84 ✓				
15	7D		R11.90 (REF)	11.90 ✓				
16	7C		16.20 (REF)	16.18 ✓				
17	7C		10.35 (REF)	10.35 ✓				
18	GENERAL		WORKMANSHIP	COMPLIANT			VISUAL AND CHECK FOR SCRATCHES / CLARITY.	
The signature indicates that all characteristics are accounted for; meet drawing requirements or are properly documented for disposition.								
12. Prepared By Mark Perry, Plas-Tech Fabrications 						13. Date 09-25-2020		



128 WALGREEN ROAD, OTTAWA, ON K0A 1L0
PHONE-613-831-4640

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: SEPTEMBER 25, 2020

YOUR PURCHASE ORDER: PO HB047008

OUR INVOICE NO: 220233

LINE ITEM # 1
QUANTITY: 6
DESCRIPTION: WINDOW FOR DWG D2958 REV E.

DAS
82
9-89

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH:

DART QSI 018

PLASTECH PROCESS PR-01-01-D2958 REV 1.0 USING DWG D2958 REV E. ✓

Note: USED 2 SHEET - 64 SF OF PLEXIGLASS G CLEAR CAST ACRYLIC SHEET PER LP-391
TYPE 1 GRADE C, 0.125 THICK (REF DART SPEC. M-ACRYLIC-S.125). BATCH# S151992. ✓

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF
THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT
SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS
AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

MARK PERRY, M.ENG.
PRESIDENT

**2684 FENTON RD
OTTAWA ON K1T 3T7
Ph. (613) 232-2657 Fax (613) 232-6214
info@canusplastics.com
www.canusplastics.com**

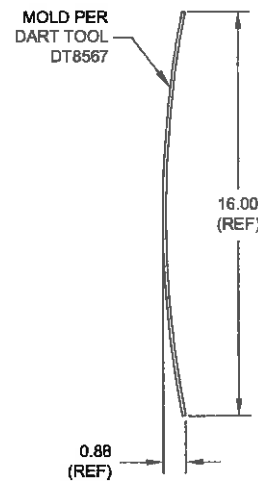
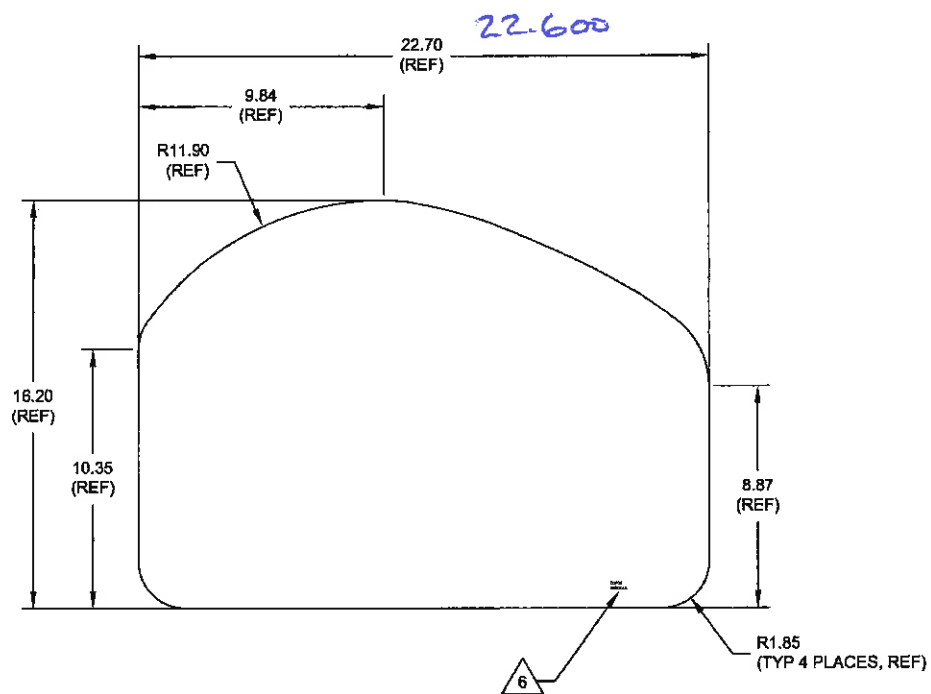
0000222437

Date September 26, 2020
Customer P23336

Ship To: DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

Ph. (613) 632-3336

PO Number	F.O.B.	Salesperson	Order Date	Order Number
POHB047008	Our Dock	Mark Perry	September 25, 2020	0000222437
Ship Via		Payment Terms	Reference	
Pick up				
Ordered by P LUSSIER				
Part Number	Description	Ordered	Shipped	Extended Weight
MFG	PART D2958P; DRAWING D2958 REV E, VARIOUS WINDOWS	6	6	
		Reg (S) <i>[Signature]</i> SEP 25 2020 <i>[Signature]</i> RECEIVED SEP 25 2020 DART AEROSPACE LTD.		
Date	Signature	Total	6	



D2958 FLAT PATTERN

RELEASED
07.09.22

D2958 WINDOW:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D2958" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.58 +/- 0.35 LBS
- 8) MOLD PER DART TOOL DT8567

E	UPDATE DIMS PER PAR 188	DC	07.07.06
D	UPDATE MATERIAL PER NCR 029	SSH	06.04.13
C	REMOVE HOLES, UNIFORMLY SMALLER	CP	01.05.30
B	Ø0.156 HOLES WERE Ø0.141 (NCR 407)	CP	00.02.23
A	NEW ISSUE	CP	00.01.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.06		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2958
TITLE WINDOW
REV. E
SHEET 1 OF 1
SCALE 1:5

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Entered: 26 Date: OCT 01 2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8510

Route update only ☐

Job: <u>212751</u> Part No. <u>D2958</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☒ Quality ☐			
---	--	--	--	--	--

Date: SEP 25 2020 Sequence #: 150 QC6 QTY Affected: 3 OF 3 MRB (QSI042) DAS 9 9-89 20-9-23

Description Work Order Deviation	Disposition	Completed By
DURING INSPECTION IT WAS FOUND THAT DIMENSION 22.70 (REF) IS 22.60. <u>SUPPLIER'S FAI RECORDED DIMENSION IS 22.65 22.650"</u> <u>DAS 32 9-89</u>	<u>- Not acceptable. scrap destroy.</u> <u>- Dimension 22.70 should be revise to have a tolerance call out.</u> <u>ECR to open <u>ECR70</u> PD 20-9-23</u> <u>-</u>	<u>82 9-89</u> <u>SEP 29 2020</u> Lead hand / Supervisor <u>DAS 9 9-89 20-9-30</u> QC / QA Coordinator <u>DAS 9 9-89 20-9-30</u>

Root Cause	FAULT CATEGORY			
Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
Other/Details:				